

# Work Order ID 69390

Tuesday, May 10, 2011 2:27:48 PM



Page 1

Item ID: D4079-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half, Attachment

Stop



Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: 11-05-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4079

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.750" long

*11/06/08*

*20*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Mill as per Dwg and Folio FA931

Folio rev:

Dwg Rev:

Deburr

*issue P/O 14260*

*CL 11/06/09 20*

*Dan's Precision machine as per  
dwg D4079 REV.B*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120 *rec'd*

~~QC2~~ Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*rec'd + inspect for transit damage  
attached c of c to W/O*

*Rec'd 5/10/11 (20)*

130

~~QC2~~ Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*8 units*

*counted  
x20  
x19*

*Pro*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*19 11-7-7*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

see pink NCR 11-720  
against ~~supplies~~ machining

Part No: D4079-1 PAR #: N/P Fault Category: Supplier NCR: Yes No DQA: Yes No Date: 11/07/15  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes No Date: 11-07-15

NCR: <u>69390</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/7/15</u>	<u>#130</u>	Found at inspection that Q4 x1 Part has a Large machining mark on the side R.C. Not noticed at Supplier inspection	<u>11/07/15</u> <u>Q51042</u>	→ Scrap + Destroy Q4 x1 No Reshar	<u>11/7/15</u>	<u>11/07/15</u>	<u>11/07/15</u>	<u>11/07/15</u>
			<u>11/07/15</u>	→ confirm supplier if found scrap. Attached copy of email conversation	<u>11/7/15</u>	<u>11/07/15</u>	<u>11/07/15</u>	<u>11/07/15</u>
				Dan's precision tools				

NOTE: Date & initial all entries

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Revision ID:

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Item Name: Clamp Half, Attachment

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

Powder Coating

0.00

Start Time: 9:50  
Temp: 320°F  
Finish Time: 10:20

19 of 11/07/12

160

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

19 of 11/04/12

170

Identify as per dwg & Stock Location 120

0.00



Packaging

Memo

Packaging

0.00

11/7/12 1910

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69390**

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Item Name: Clamp Half, Attachment

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13

ME  
11-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 10, 2011 2:27:55 PM

Page 1  
✓

Work Order ID: 69390



Parent Item: D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 5/10/2011

Required Date: 5/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV: A NEW ISSUE 10\*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	28.0900	0.23	4.842105			



6061-T6 Bar 2.00 x 2.00

Location

Loc Qty

Loc Code

MAT009

28.09

113006

11

113123

11

13085

6.09

4.9 f 11/06/08

D4079-1P

Rec'd 7/5/20

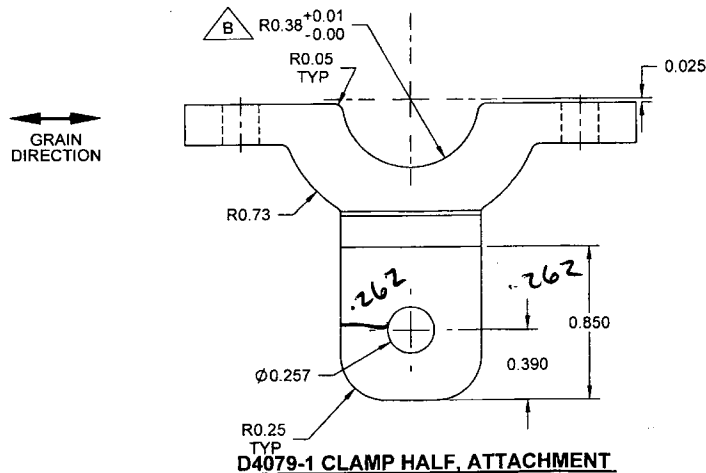
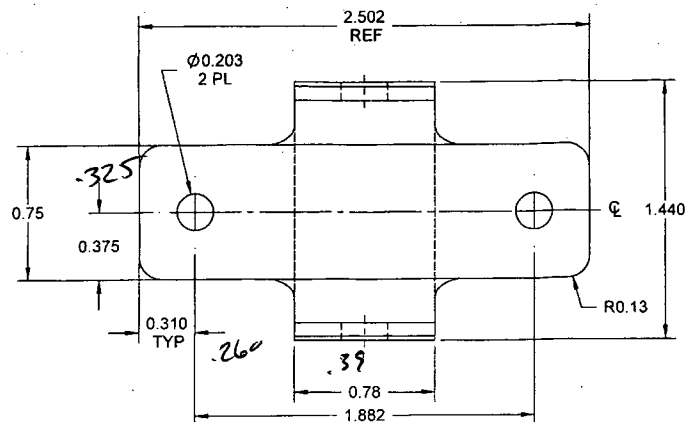
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

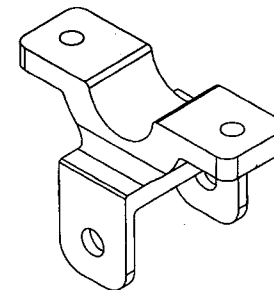
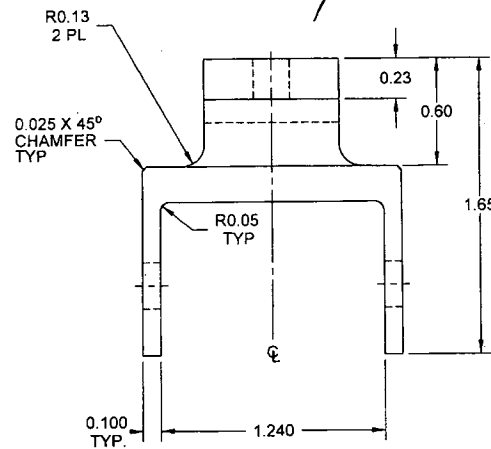
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D4079-1 CLAMP HALF, ATTACHMENT**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 09390  
*11-05-4*

**RELEASED**  
2010-09-07  
*MP*

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48	KB	10.07.30
A	NEW ISSUE	KB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		KB	
DRAWN		KB	
CHECKED		KB	
MFG. APPR.		KB	
APPROVED		KB	
DE APPR.		KB	
DATE	10.07.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4079</b>	REV. B
TITLE <b>CLAMP HALF, ATTACHMENT</b>	SHEET 1 OF 1
SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A3H0  
Tel:(613) 835-3097 Fax:(613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**



**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.



**Date** : 04-Jul-11  
**Purchase Order** : PO14260  
**Packing Slip** : 10537  
**Part Number** : D4079-1revB  
**Quantity** : 20



Per: \_\_\_\_\_

For Dan's Precision Tools Inc.

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE

P.O.: PO14260

W/O: \_\_\_\_\_

Part #: D4079-1 rev B

Clamp Half, Attachment

Qty: 20

1

of

1

**To:**  
**Subject:**

Khaled - Dan's Precision Tools (khaled@dans-precision-tools.com)  
D4079-1 CLAMP TOOL RUN OFF

Hi Khaled,

FYI, On one of the these clamps, there is a mark which appears that was done by the chamfer tool by the 3/8" bore. Don't worry about the credit, I'm just letting you know so you can fix the nc program for future parts.

THX

JLM

**Jean-Luc Menard**

*Production Engineering Coordinator*



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200 Ext 227

jmenard@dartaero.com



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